

machining the previously cold-headed one end portion to form a cam engaging portion of said wear resistant shoe; and

subsequently cold-working and thereby hardening the opposite end portion.

10. (Twice Amended) A method of manufacturing a wear resistant shoe, comprising:
work hardening a portion of a cylindrical member to a substantial depth while leaving another portion of the cylindrical member dimensionally unchanged and maintaining cold-workability of said another portion;

machining the work-hardened cylindrical member portion to finished dimensions, thereby forming a cam engaging portion of said wear resistant shoe; and
surface hardening a face of the machined cylindrical member portion.

11. (Amended) The method of claim 10, including the additional step of machining said another portion of the cylindrical member to form a hollow skirt in said another portion for receiving a rounded end of a piston rod.

15. (Twice Amended) A method of forming and assembling a piston and wear resistant shoe, the shoe formed from rod stock of a diameter less than the greatest diameter of the finished shoe, comprising:

upsetting one end portion of the rod stock to axially reduce and radially increase the dimensions of the one end portion, and to work harden the one end portion while leaving

an opposite end portion dimensionally unchanged and maintaining cold-workability of the opposite end portion;

machining the previously upset one end portion to form a cam engaging portion of said wear resistant shoe;

forming a hollow region in an opposite rod stock end portion; and

crimping the periphery of the hollow region about a rounded end of the piston rod.

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